

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58643

Wednesday, May 12, 2010 1:48:24 PM



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Item ID: D3684-045

Accept



Setup Start



Revision ID:

Stop



Item Name: LEG ASSEMBLY

Start Date: 5/13/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/6/23

(S)

130

Identify as per dwg & Stock Location: 1390 0.00



Packaging

Memo

0.00

Packaging

P 10/6/23 (3)

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/6/24 J

CL 10/6/24

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Picklist Print

Wednesday, May 12, 2010 1:48:23 PM

Page 1

Work Order ID: 58643

Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Date: 5/13/2010

Required Date: 5/21/2010

Start Qty: 3.00

Required Qty: 3.00

AN3C12A

Purchased

No

110

Each

104.0000

2



Bolts

Location

Loc Qty

Loc Code

ST351

104

112314

104

D3688-5

Manufactured

No

110

Each

9.0000

1



STUD

Location

Loc Qty

Loc Code

ST081

9

46054

9

D3689-1

Manufactured

No

110

Each

16.0000

1



SLEEVE

Location

Loc Qty

Loc Code

ST082

16

55638

11

56335

5

D3691-1

Manufactured

No

110

Each

1.0000

1



STUD

Location

Loc Qty

Loc Code

ST082

1

54859

1

~~B58634~~ B58631

SS 10/06/23

SS 10/06/23

SS 10/06/23

SS 10/06/23

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 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 3.00

Required Qty: 3.00

D3692-1 Manufactured No 110 Each 521.0000 4



SPACER

Location	Loc Qty	Loc Code
ST082	521	
50736	113	
51467	408	

6 SB 10/06/23

D3693-1 Manufactured No 110 Each 63.0000 1



Rod End Bearing

Location	Loc Qty	Loc Code
ST082	63	
50734	63	

3 SB 10/06/23

MS21043-3 Purchased No 110 Each 3,635.000 2



Nut

Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST301	3555	
112314	3555	

6 SB 10/06/23

NAS509-12C Purchased No 110 Each 69.0000 1



Nuts

Location	Loc Qty	Loc Code
ST280	69	
112453	69	

3 SB 10/06/23

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Shop Packet Print

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IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 3.00

Required Qty: 3.00

NAS509L12C

Purchased

No

110

Each

74.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

74

112314

64

112828

10

3

86 10/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

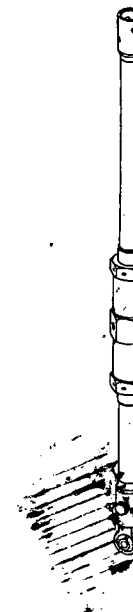
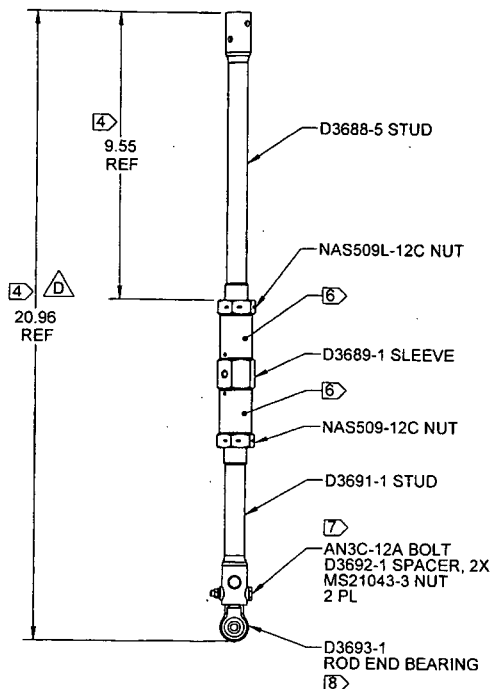
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-045 INBOARD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWING	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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